

Work Order ID 69187 -2



Page 1

Wednesday, May 04, 2011 11:17:53 AM

Item ID: D3494-1

Accept



Setup Start



Revision ID:

SPUT

Item Name: Stub Cover

Stop



Start Date: 5/4/2011 Start Qty: 13.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 13.00



Customer:

Reference:

Approvals:

Process Plan:

11

Date: 11-05-4

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3494

Rev D

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: 8

Prog Rev: D

304. 063

2-Deburr if necessary

B11-5-4



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 13.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 4/6/10/11

(14)

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

S 4/6/11

(14)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 4/6/11

(14)

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Item Name: Stub Cover

Start Date: 5/4/2011 Start Qty: 13.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 13.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

144



Large Fab

Weld per dwg A/R S.S. rod Batch: M107057 0.00

Memo

0.00

1- WELD
2- GRIND AS PER DWG11-5-17

146



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

5/11/11

147



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/11/11

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Page 4

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Accept



Setup Start



Revision ID:

Stop



Item Name: Stub Cover

Start Date: 5/4/2011 Start Qty: 13.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 13.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M115128

Memo

0.00

Powder Coating

2 BR 11-5-19

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 6 11/05/19

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

Pack 10/19 (2)

W/O:		WORK ORDER CHANGES					
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Work Order ID 69187


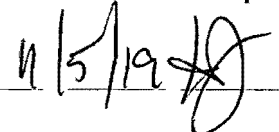
Wednesday, May 04, 2011 11:17:53 AM

Page 5

Item ID: D3494-1 Accept  Setup Start 
Revision ID:
Item Name: Stub Cover Stop 
Start Date: 5/4/2011 Start Qty: 13.00  Cust Item ID:
Required Date: 5/5/2011 Req'd Qty: 13.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/5/19 	

mf
11-05-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 04, 2011 11:17:59 AM

Page 1

Work Order ID: 69187



Parent Item: D3494-1



Parent Item Name: Stub Cover

Start Date: 5/4/2011

Required Date: 5/5/2011



Start Qty: 13.00

Required Qty: 13.00

Comments:

IPP Rev:A New Issue 06-05-18 JLM
 IPP rev B ecn 888 06.12.13 EC
 add welding DD 10.03.03 verifie by:EC
 chg design EC verified by:DD

IPP Rev:C
 lpp RevD ECN 10-555

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	108.5000	0.72	9.852632			
										B11-5-4			
304/316 Sheet .063													

Location

Loc Qty

Loc Code

MAT020

108.5

117275

108.5

117275

14

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DART AEROSPACE LTD		Work Order:	49187
Description: Stub Cover		Part Number:	D3494-1
Inspection Dwg: D3494	Rev: D	Page 1 of 1	

☒ **First Article** ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.208	+/-0.010	0.209	x		V B02	
0.368	+/-0.010	0.368	x		V	
0.766	+/-0.010	0.767	x		V	
2.508	+/-0.010	2.509	x		V	
6.278	+/-0.010	6.276	x		V	
8.039	+/-0.010	8.037	x		V	
8.437	+/-0.010	8.440	x		PROW502	
8.805	+/-0.010	8.814	x		P	
1.832	+/-0.010	1.827	x		V	
3.262	+/-0.010	3.255	x		V	
3.604	+/-0.010	3.601	x		V	
3.940	+/-0.010	3.940	x		V	
7.544	+/-0.010	7.544	x		V	
7.887	+/-0.010	7.881	x		V	
9.317	+/-0.010	9.320	x		P	
11.148	+/-0.010	11.155	x		P	
0.060	+/-0.010	0.058	x		V	

Measured by: JB	Audited by: S	Preliminary Approval:
Date: 11-5-4	Date: 11/05/04	Date:

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	10.02.18	Dimensions updated per Dwg Rev C	KJ	
C	11.04.28	Dimensions updated per Dwg Rev D	KJ	

Dart Aerospace Ltd

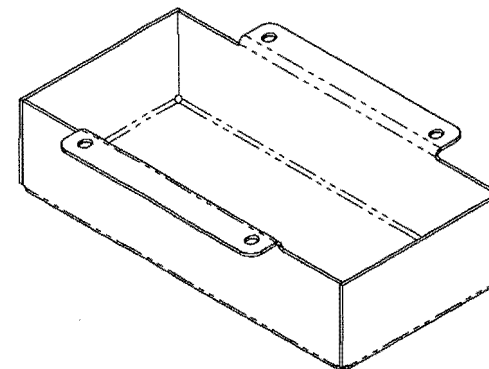
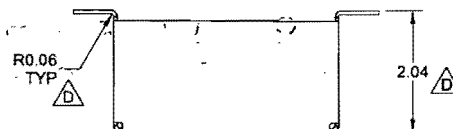
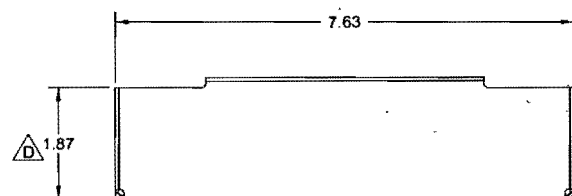
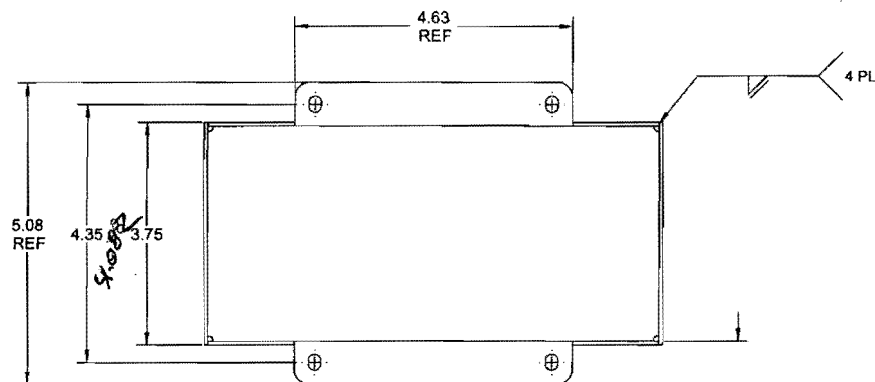
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09187 *11-05-4*

D3494-1 STUB COVER

RELEASED
2010-04-26
MD

NOTES:

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.29 lbs
- 8) WELD PER DART QSI 004

D	TOLERANCE WAS 3 DEC. PLACES (ZN B5-1); 1.87 WAS 1.88 (ZN B8-1); 2.04 WAS 2.00 (ZN B3-1); REVISED D3494-1F (ZN A8-2); CORRECTED WEIGHT INFO (ZN A8-1); UPDATED MATERIAL (ZN A8-2); REASON: SEE NCR#10-037.	MB	10.04.15
C	DRAWING TRANSFERRED TO "B" SIZE, GENERAL REVISION TO FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. CS-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALL OUT". CS-1 0.67 DIM WAS 0.65, B8-1 1.90 DIM WAS 1.88 B3-1 & 2.04 DIM WAS 2.00. REFER TO PAR 08-003 FOR FURTHER DETAILS.	AJS	08.10.31
B	REVISED FLAT PATTERN, BENDING DIMENSIONS, Ø0.208 X 0.268 SLOTS WERE Ø0.208 HOLES.	MB	06.11.28
A	NEW ISSUE	MB	06.01.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3494
REV. D
SHEET 1 OF 2
TITLE
STUB COVER
SCALE
NTS

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NOTE: Date & initial all entries

8.805
8.437
8.039

6.329
6.278
6.128

2.678
2.528
2.476

0.766
0.368
0

1.710
1.832
1.912

3.262
3.604

7.544
7.887

9.237
9.317
9.438

11.148

SYMM

R0.25

R0.060
TYP

SYMM

D3494-1F STUB COVER FLAT PATTERN

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.060 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

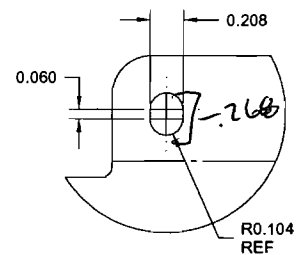
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE COMPLETED PART WEIGHT

u6 6A187



DETAIL A
SLOT DETAIL 4 PL
SCALE 2X

RELEASED
2010-04-26
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3494	REV. D
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE STUB COVER	SCALE NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.15		

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